



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-751-011
Job Sheet 167570-A



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/2/17

Job Tracking No:

Due Date: 11/30/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Metro Aviation Inc (CMETR01)

PO Box 7008 Shreveport, LA, 71137 USA ph:(318) 222-5529 fx:(318) 698-5205.

Ship Via: *REU A*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Skidtubes		<i>TW</i>
120	Skidtubes	1 pcs		11/29/17	0.00	0.80	Skidtubes		<i>TW</i>
140	QC	1 pcs		11/29/17	0.00	0.00	QC5		
150	HandFinish	1 pcs		11/29/17	0.00	0.33	HandFinish1		<i>2017-11-16 JSL</i>
160	QC	1 pcs		11/29/17	0.00	0.00	QC7		<i>BE</i>
170	Skidtubes	1 pcs		11/29/17	0.00	1.00	Skidtubes		<i>BE</i>
180	QC	1 pcs		11/29/17	0.00	0.00	QC10		<i>38</i>
185	HandFinish	1 pcs		11/29/17	0.00	0.10	HandFinish6		<i>2017-11-30 JSL</i>
187	QC	1 pcs		11/29/17	0.00	0.00	QC7		<i>BE</i>
190	Skidtubes	1 pcs		11/29/17	0.00	0.77	Skidtubes		<i>BE</i>
200	QC	1 pcs		11/29/17	0.00	0.00	QC5		<i>17-12-12 JSL</i>
210	HandFinish	1 pcs		11/29/17	0.00	0.08	HandFinish2		<i>2017-12-13 JSL</i>
220	SprayPaint	1 pcs		11/29/17	0.00	0.25	Spray Paint		<i>JAN 15 2018</i>
230	QC	1 pcs		11/29/17	0.00	0.00	QC14		<i>38</i>
260	HandFinish	1 pcs		11/30/17	0.00	0.74	HandFinish4		<i>BE</i>
270	QC	1 pcs		11/30/17	0.00	0.00	QC5		<i>38</i>
280	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging1		<i>MAR 07 2018</i>
290	QC	1 pcs		11/30/17	0.00	0.00	QC4		<i>BE</i>
295	DC	1 pcs		11/30/17	0.00	0.00	DC		<i>BE</i>
300	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		<i>BE</i>
310	QC21-FG	1 Ea		11/30/17	0.00	0.00	QC21		<i>MAR 16 2018</i>

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES**** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Debur holes.

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507, and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Debur and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time *11:30:54* end time: *EXT 2018-04-21* 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Debur Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

DART
AEROSPACE
S009535



Skidtube with Standard Wearplates Fits LH or RH

PART NO:
Revision:
Operation:
Change No:

D135-751-011

Start up Operation

Mfg Date: 11/13/17
Job No: 167570-A

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: 137670 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: 138714

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 1138711

295 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3507-1-BENT <u>163194</u>	①	9	0	0
170-Skidtubes	D3504-1 <u>B153788</u>	2	6	0	0
	D3504-3 <u>B105604</u>	1	34	0	0
	D3504-5 <u>F153746</u>	2	10	0	0
	D3505-1 <u>S008623</u>	1	1	0	0
190-Skidtubes	D3506-1 <u>F164752</u>	④	28	0	0
	D3506-3 <u>B131267</u>	②	24	0	0
	MS20601-AD4W3C <u>S016824</u>	⑫	150	0	0
260-HandFinish	ALS4-1032-225 <u>F135998-2</u>	1	879	0	0
	<u>1154</u> <u>AL87-1032-130</u> <u>S007279</u>	38	109	0	0
	AN3C4A <u>S019394</u>	31	1,600	0	0
	AN3C5A <u>S019396</u>	2	412	0	0
	AN526C1032R10 <u>F1137851-4</u>	2	137	0	0
	D2965 <u>S045476</u>	1	15	0	0
	D2965-3 <u>F126369</u>	1	59	0	0
	D3492-1 <u>F165386</u>	4	59	0	0
	<u>2 x F165369</u> D3492-3 <u>F163469x2</u>	4	101	0	0
	D3492-7 <u>F106110</u>	2	53	0	0
	D4918-047 <u>S036145</u>	1	8	0	0
	D4918-1 <u>A163420-128</u>	1	5	0	0
	D4918-3 <u>S015516</u>	1	2	0	0
	D4918-5 <u>F165082</u>	1	6	0	0
	NAS1149C0332R <u>S027570</u>	33	4,240	0	0
	NAS1611-007 <u>F103697</u>	2	308	0	0
	NAS1611-010 <u>F1137587-3</u>	4	123	0	0
	NAS1611-013 <u>F1137333x1</u>	4	117	0	0
280-Packaging	AN3C4A <u>F1138238-40</u>	8	1,600	0	0
	D3512-041 <u>S04891A</u>	2	12	0	0
	NAS1149C0332R <u>S014380</u>	8	4,240	0	0

Part Specifications

Specifications could not be found.

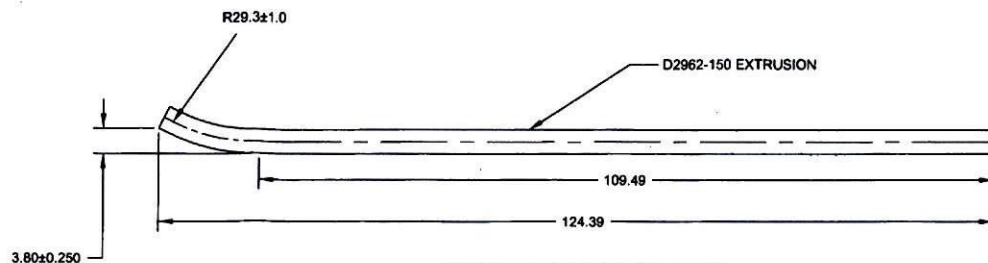
Plex 11/2/17 3:26 PM dart.Michaud-Febrille.Victoria

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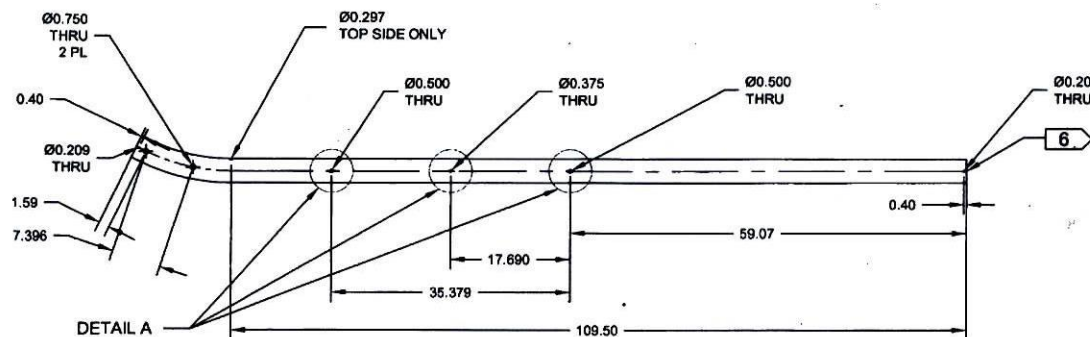
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN980C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

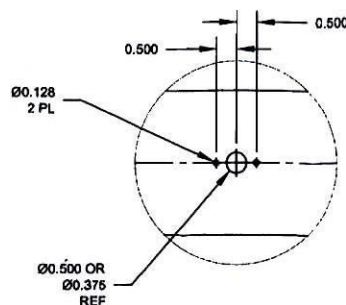
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8988 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN980C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL

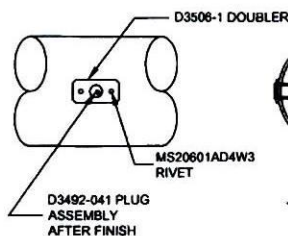


D3507-1 DRILLING DETAIL



DETAIL A
TYP, 6 PL
SCALE 3:10

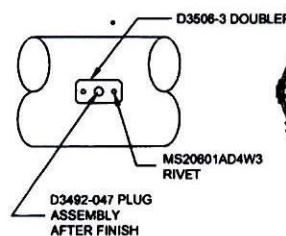
D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



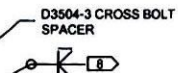
SECTION C-C
(SCALE 3:10)



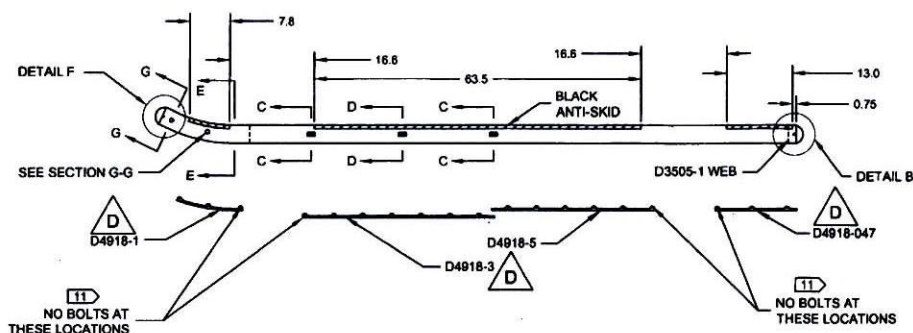
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL



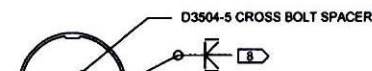
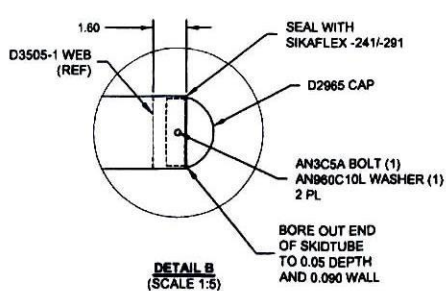
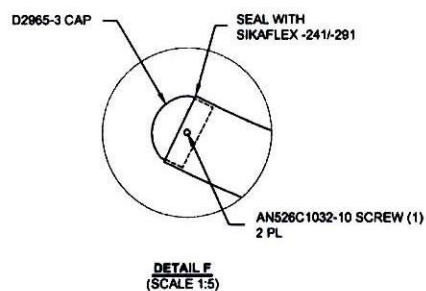
SECTION D-D
(SCALE 3:10)



- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL

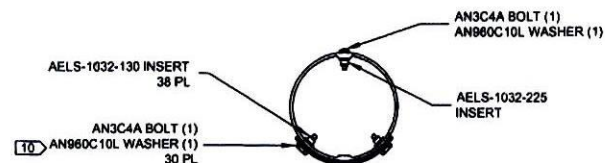


D3507-041 ASSEMBLY DETAIL



SECTION G-G
(SCALE 3:10)

- AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



SECTION E-E
(SCALE 3:10)

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.		D3507	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2013-12-10